

Work Order ID 77355

77355

Page 1

December-06-11 10:27:58 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop *NS2*

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/06 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100 DOCUMENT CONTROL 0.00

100

DC Memo 0.00

Document Control Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

12/01/18

MLJ 12-1-10 (5)

110 Large Fab 0.00

110

Large Fab Memo 0.00

Large Fab 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 114514

119712

3-Grind End Plate flush

12.01.03 5

77355 5LH. ☺

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77355***77355***

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December-06-11 10:27:58 AM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

5 0 BE12-01-04

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

812/01/0445 44

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1A 12-01-055

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long LH
 Start Date: 06/12/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 30/01/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

564 4 11/12/06
 counted & measured

180	Large Fab	0.00							
180									
Large Fab	Memo	0.00							
Large Fab									

(x5) 0

- 1-Assemble Leg Assembly as per Dwg D3272.
- 2-Leave one rivet out until welding is complete.
- 3-Bevel Aft end for welding
- 4-Inspect for foreign object as per QSI 024
- 5-Weld Aft End Plate as per QSI 004 & Dwg D3272
 A/RAluminum Rod 114514
- 6-Grind End Plate flush
- 7-Install last rivet as per Dwg.

Ac 12.01.06
 12.01.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		<i>6 12/01/13</i>					
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 12/01/13</i>		<i>75</i> <i>LM</i>			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>5</i>	<i>BL 10-1-16.</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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 Item Name: Heli-Access-Step, Long LH
 Start Date: 06/12/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 30/01/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220 Powdercoat Powder Coating	Memo START TIME: <u>8:15</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>8:45</u>	0.00							SXV M/L 12/01/17 LH
230	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
230 HandFinish Hand Finishing	Memo	0.00							SLA. M 12-1-17
240	QC3- Inspect Part Finish	0.00							
240 QC Quality Control	Memo	0.00							SLH d M 12/01/17 counted and identified

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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77355

December-06-11 10:27:58 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

5

5

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

250	Pick Kit	0.00	
-----	----------	------	--

Pick Kit

0.00

Memo

0.00₂

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

0.00

Packaging

0.00

Memo

Identify and pack for shipping as per PPPD350-591-311

Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

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Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/1/19 *[Signature]*
R12-049
(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-06-11 10:28:01 AM

Page 1

Work Order ID: 77355

77355

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 *D3272-1* Step		Manufactured	No			110	Each	20.0000	1	5		11.12.28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	377360			5					
					76038			10					
					76039			10					
D3067-1 *D3067-1* End Plate		Manufactured	No			110	Each	125.0000	1	5		12.01.02	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016				125					
					67582			2					
					68214			1					
					75468			32					
					76179			90					
D3219-1 *D3219-1* Plate		Manufactured	No			110	Each	106.0000	2	10		12.01.02	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016	71674			106				10	
					73410			34					
					76226			72					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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December-06-11 10:28:01 AM

Work Order ID: 77355

77355

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 148.0000 2 10

D3066-1

**

Ac 12.01.06

Spacer

Location

Loc Qty

Loc Code

WA015

148

75076

48

76180

100

X10

MS20600-AD4W4 Purchased No

180 Each 2,362.000 16 80

MS20600-AD4W4

**80 m119883 Ac 12.01.06

Rivets

Location

Loc Qty

Loc Code

ST321

m119883

2357

116188

59

117364

253

117601

200

117885

195

118840

1150

119860

500

80

WA018

5

116712

5

D3065-041 Manufactured No

180 Each 33.0000 1 5

D3065-041

**

B77054 (x5) Ac 12.01.06

Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

B77054

33

66149

0

76193

31

76194

2

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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December-06-11 10:28:01 AM

Work Order ID: 77355

77355

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1 Manufactured No

180 Each 125.0000 1 5

D3067-1

End Plate

**

Handwritten: 12.01.09

Location Loc Qty Loc Code

WA016 125
67582 2
68214 1
75468 32
76179 90

AN3-35A Purchased No

250 Each 145.0000 2 5

AN3-35A

Bolt

**

Handwritten: 5, 10, SP

Location Loc Qty Loc Code

ST353 145
117619 3
119449 100
119641 42

D3235-1 Manufactured No

250 Each 147.0000 2 10

D3235-1

Mounting Lug

**

Handwritten: 10, P

Location Loc Qty Loc Code

ST481 147
73411 47
75547 100

D3278-041 Manufactured No

250 Each 62.0000 1 5

D3278-041

Support Assembly

**

Handwritten: 10, 5, 12/1/11, 02

Location Loc Qty Loc Code

ST481 62
76169 35
76170 27

Handwritten: 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 77355

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased No

250 Each 0.0000 16 80

AN960JD416

Washer

**

AN960JD516 NAS1149D0563J Purchased No

250 Each 0.0000 4 20

AN960JD516

Washer

**

AN5-36A Purchased No

250 Each 144.0000 2 10

AN5-36A

Bolt

**

Location

Loc Qty

Loc Code

ST340

144

118451

19

119449

50

119641

75

D2618 Manufactured No

250 Each 152.0000 2 10

D2618

Bushing

**

Location

Loc Qty

Loc Code

ST019

152

74458

52

76130

100

D2230-3 Manufactured No

250 Each 99.0000 4 20

D2230-3

Lug

**

Location

Loc Qty

Loc Code

ST480

99

53881

4

70973

1

74440

10

75546

84

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

252.2445 1.2

D2856-400

Abraison Strip

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST409

252.2445

63735

0.6696

68076

0.3149

71164

37.86

73491

213.4

[Handwritten 'b']

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

7,467.000 2 10

MS21042L3

Nut

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST300

87

117441

16

117885

35

118451

5

118927

31

ST516

5994

119017

5994

ST518

1386

119075

1386

[Handwritten '10']

AN4-13A

Purchased No

250 Each

981.0000 8 40

AN4-13A

Bolt

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST357

981

118078

17

118838

364

119449

500

119798

100

[Handwritten '40']

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

2,192.000

2

MS21042L5

**

Nut

Location

Loc Qty

Loc Code

ST300

692

116105

5

116548

43

117611

52

118179

496

118910

96

ST518

1500

119109

1500

MS21042L4

Purchased

No

250

Each

10,136.00

8

MS21042L4

**

Nut

Location

Loc Qty

Loc Code

ST300

531

117441

51

117601

347

118451

133

ST516

4605

119017

4605

ST518

5000

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

AN960JD10

**

Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77355 M.L.5

11/12/06

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

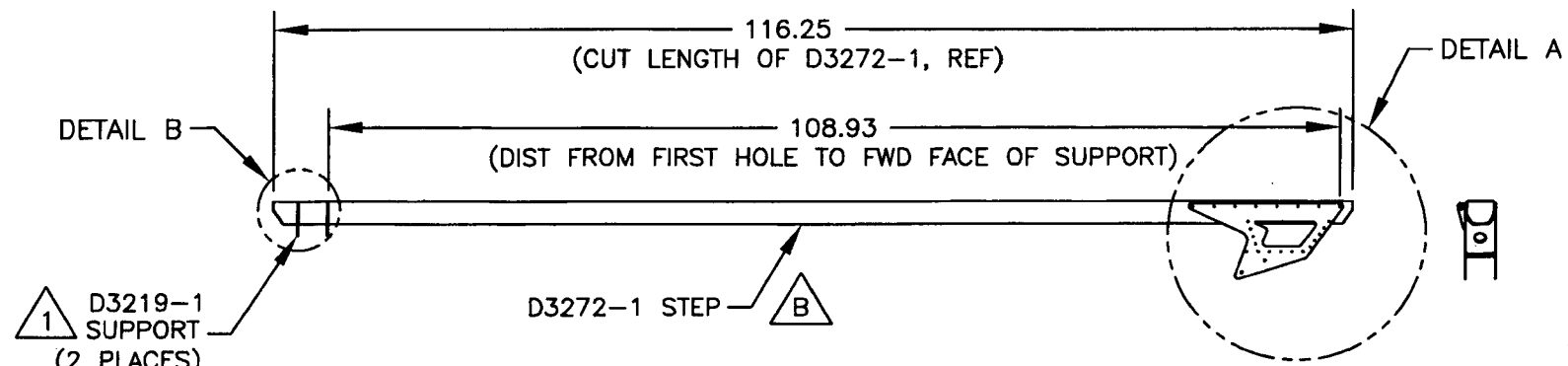
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

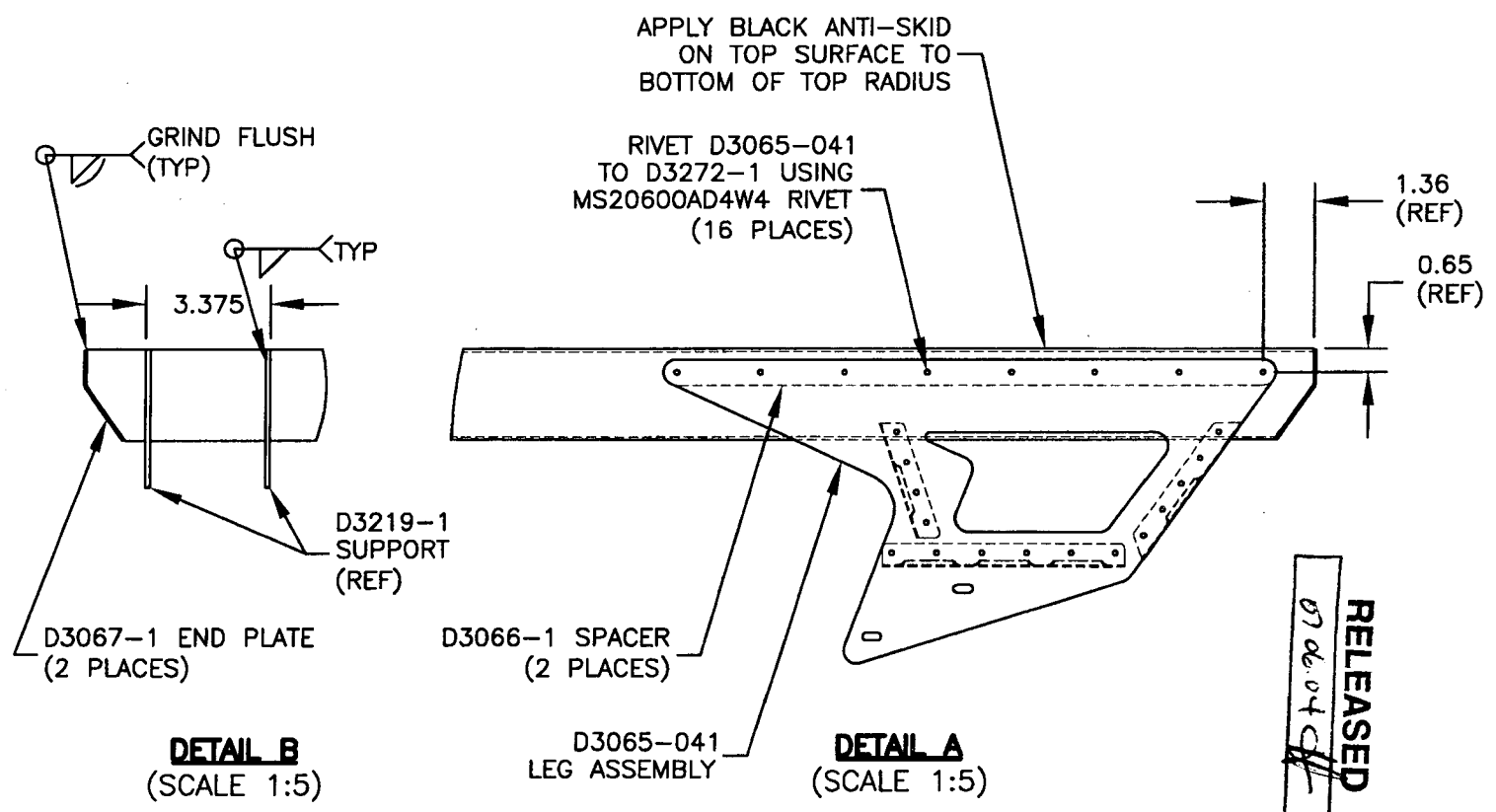


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20

RELEASED
07.06.04



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

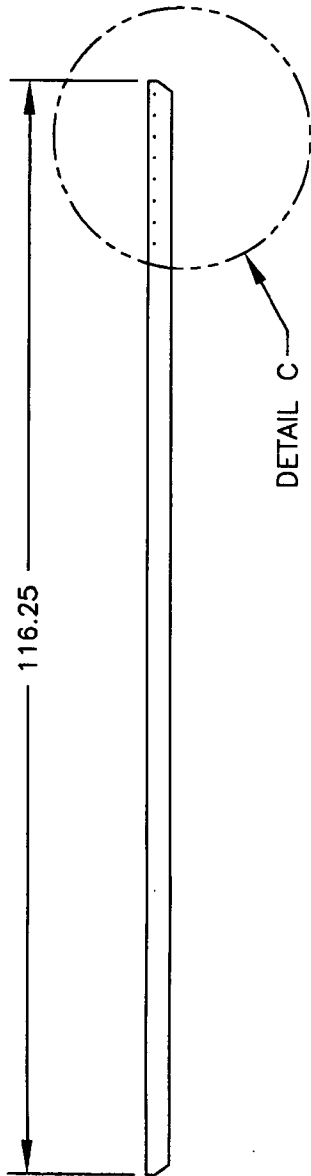
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

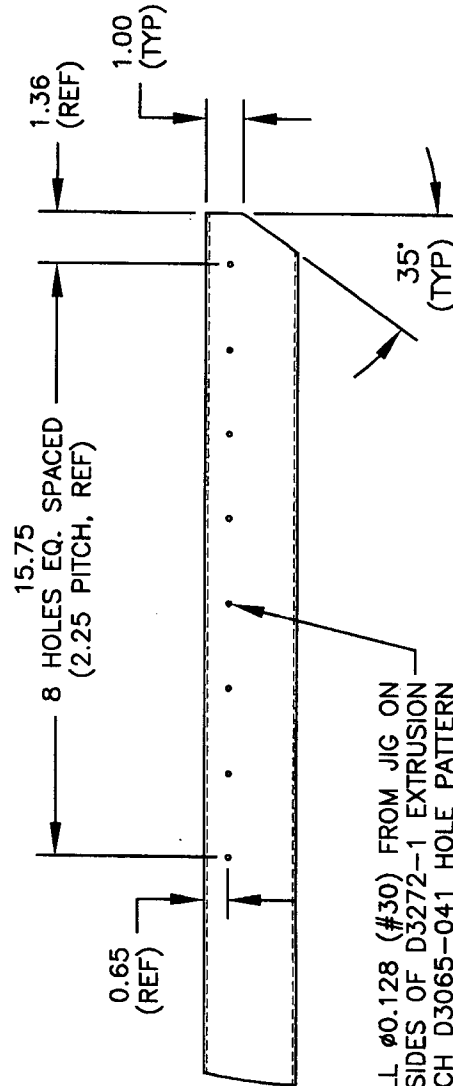
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.